

Date: Tuesday, 8/21/2007 3:43:16 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRAME WELDMENT
Job Number	: 34177		
Estimate Number	: 11202		
P.O. Number	: <i>N/A</i>	Part Number	: D3330041
This Issue	: 8/21/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3330 REV C
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 30950	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 9/15/2007 Qty: 2 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. A 05.01.13 New Issue KJ/JLM est B 07.05.14 revC dwg ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33301	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-1	Panel	<i>B30955</i>
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[Signature]
07-09-26

2.0	D33302	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-2	Panel	<i>B30958</i>
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[Signature]
07-09-26

3.0	D33303	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

Qty Part Number Description Batch

1	D3330-3	Panel	<i>B30959</i>
---	---------	-------	---------------

[Signature]
07-09-26

4.0	D33305	Rail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rail

Pick:

Qty Part Number Description Batch

1	D3330-5	Panel	<i>B30960</i>
---	---------	-------	---------------

[Signature]
07-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 34177

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D33307

Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Panel

Pick:

✓ Qty Part Number Description Batch
1 D3330-7 Panel B34122

Plot. 09-26

6.0

D33309

Top Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Top Plate

Pick:

✓ Qty Part Number Description Batch
1 D3330-9 Panel B34199

Plot. 09-26

7.0

D333011

Long Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Long Pin Bracket

Pick:

✓ Qty Part Number Description Batch
1 D3330-11 Long Pin Bracket B23590

Plot. 09-26

8.0

D333013

Short Pin Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Short Pin Bracket

Pick:

✓ Qty Part Number Description Batch
1 D3330-13 Short Pin Bracket B23235

Plot. 09-26

9.0

D333015

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle

Pick:

✓ Qty Part Number Description Batch
1 D3330-15 Handle B34198

Plot. 09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:16 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 34177

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D333017

Handle Socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Socket

Pick:

Qty Part Number Description Batch
1 D3330-17 Handle Socket

330956

Plat. 09.26

11.0

D333019

Handle Rim



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Handle Rim

Pick:

Qty Part Number Description Batch
1 D3330-19 Handle Rim

330957

Plat. 09.26

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble and Weld as per Dwg Dwg D3330 using D3330-041T1

Identify as D3330-041

Plat. 09.26

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 07-09-27 (2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Inspected on Helicopter



Comment: INSPECT WORK TO CURRENT STEP

5 07-09-26 (72)

15.0

POWDER COATING

POWDER COATING



m18052



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Plat 07/09/27 (2)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

5 07/09/27 (72)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: RD Date: 21/09/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:16 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRAME WELDMENT

Job Number: 34177

Part Number: D3330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Cr/4/28 (2)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

Done 10/9/28

Job Completion



u 8/24/28

Dart Aerospace Ltd

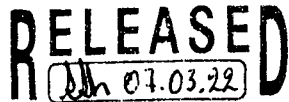
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

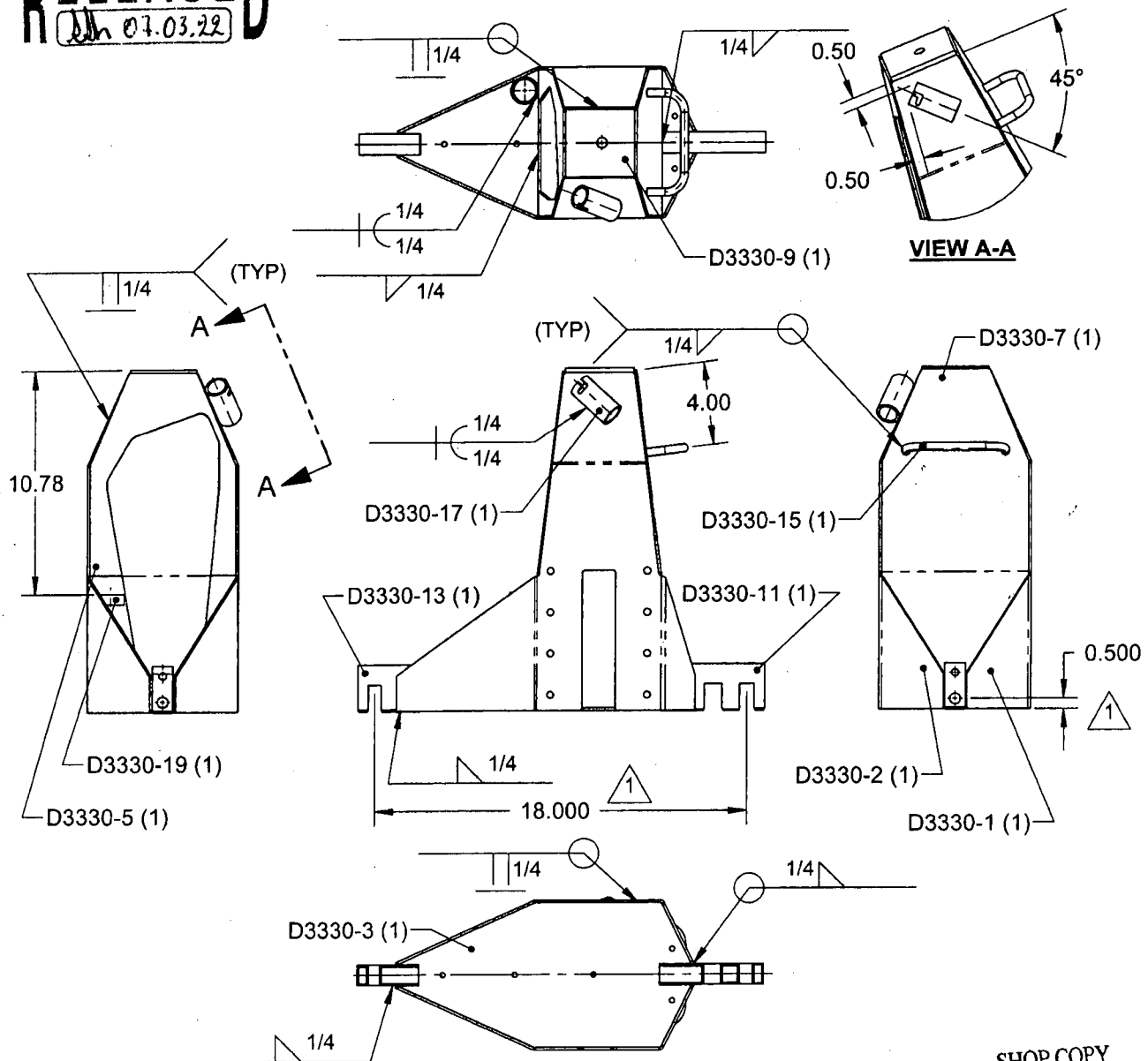
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/-2 BY 0.125	



NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
2) WELD PER QSI 004
3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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5 4.3 WORK ORDER
NO. 34177

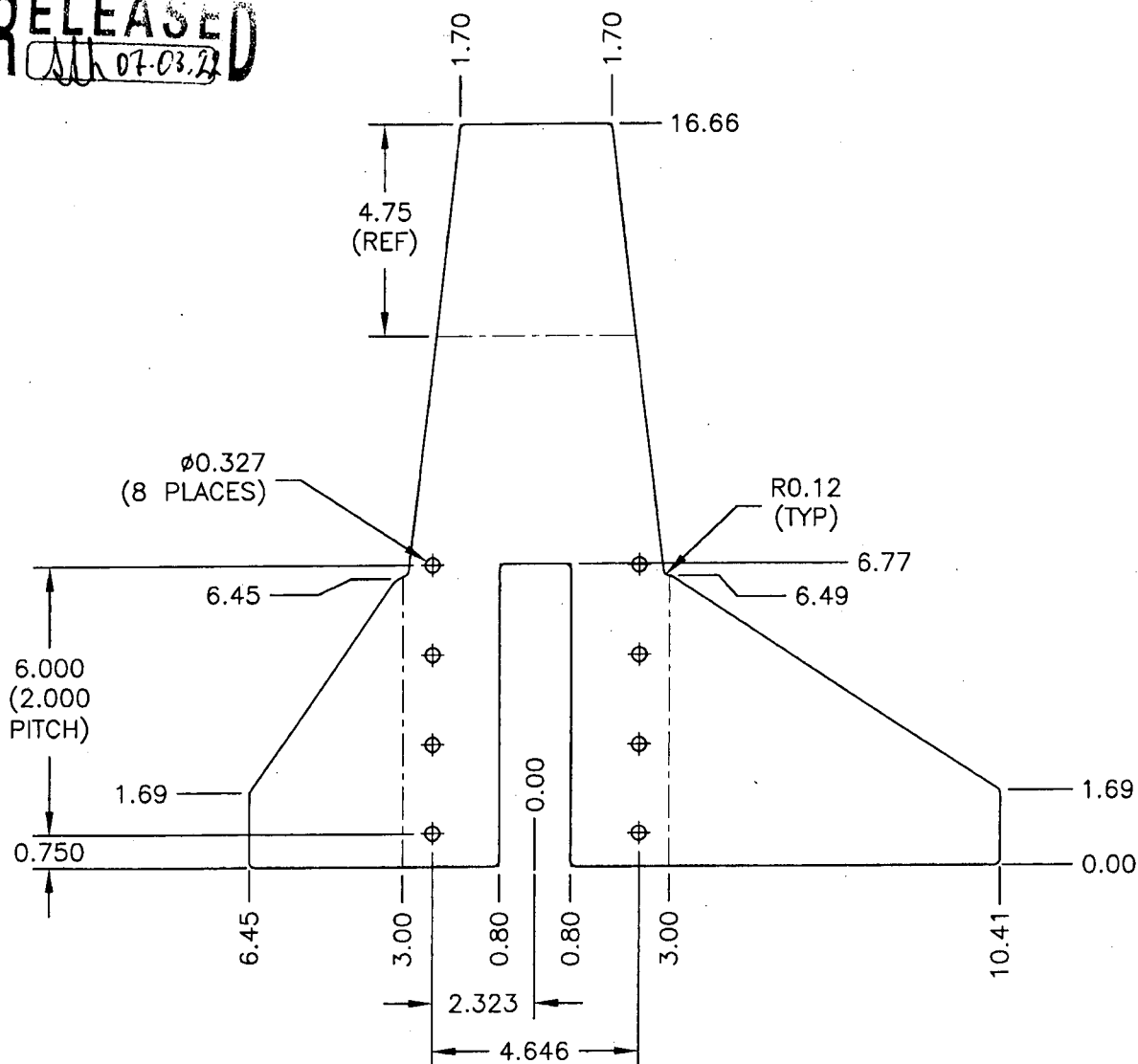
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07-03-20



D3330-1 PANEL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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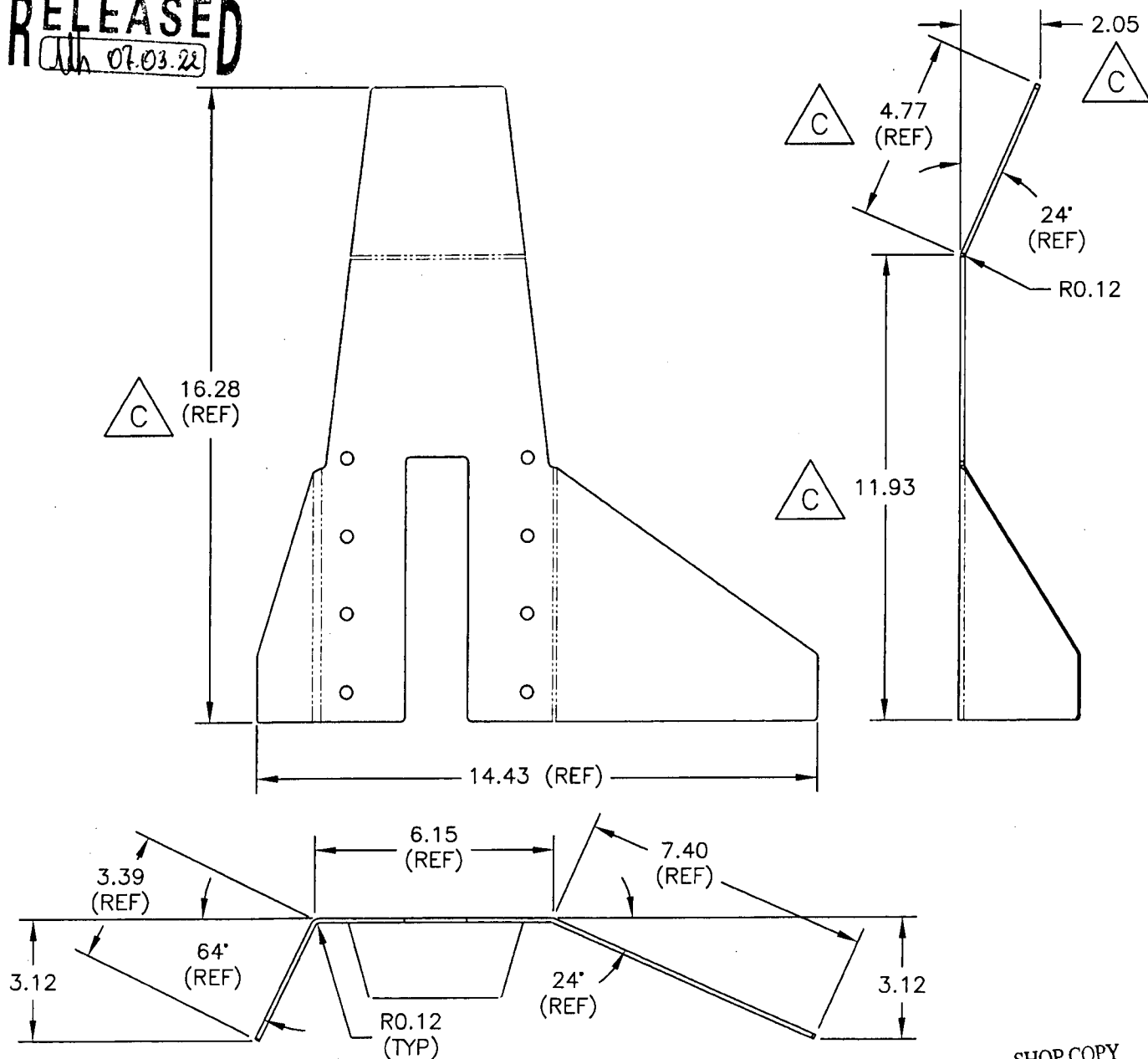
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
[Signature] 07.03.22



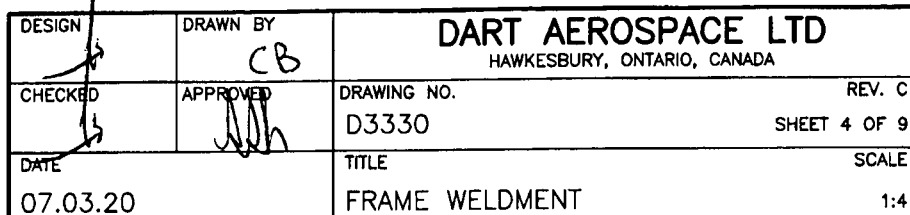
D3330-1 BEND DETAIL (SHOWN)

BEND D3330-2 (OPPOSITE)

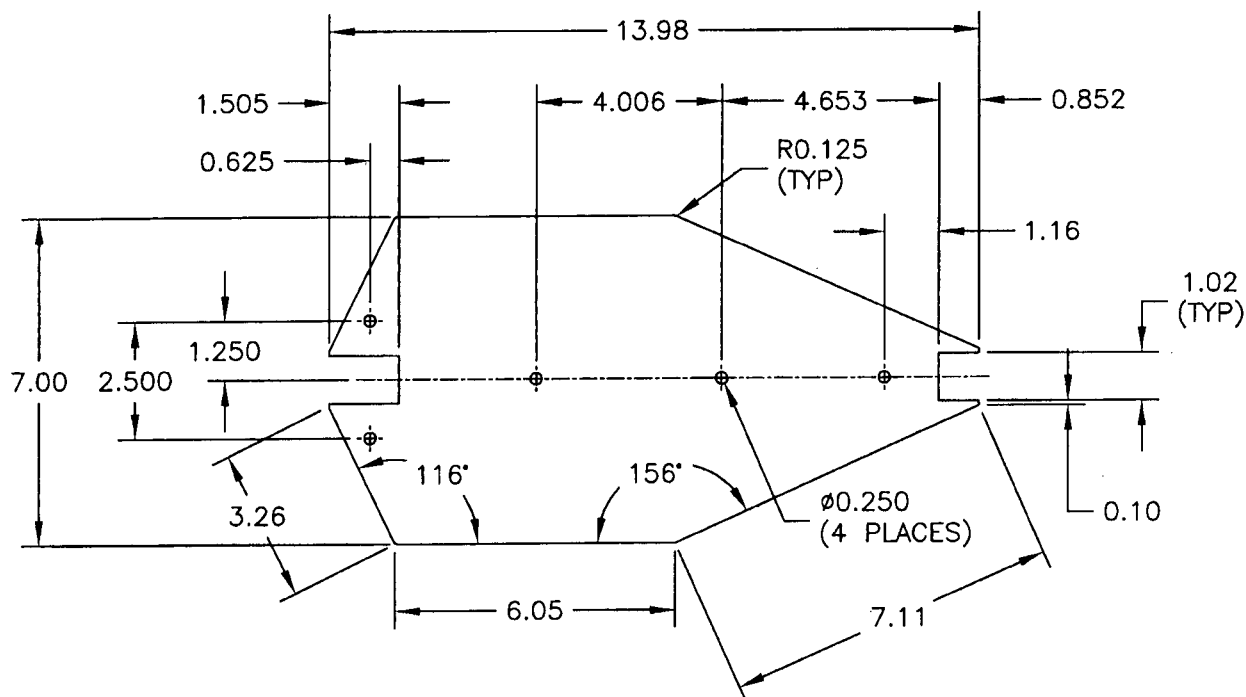
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JUL 07-03-24



D3330-3 PLATE

1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
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3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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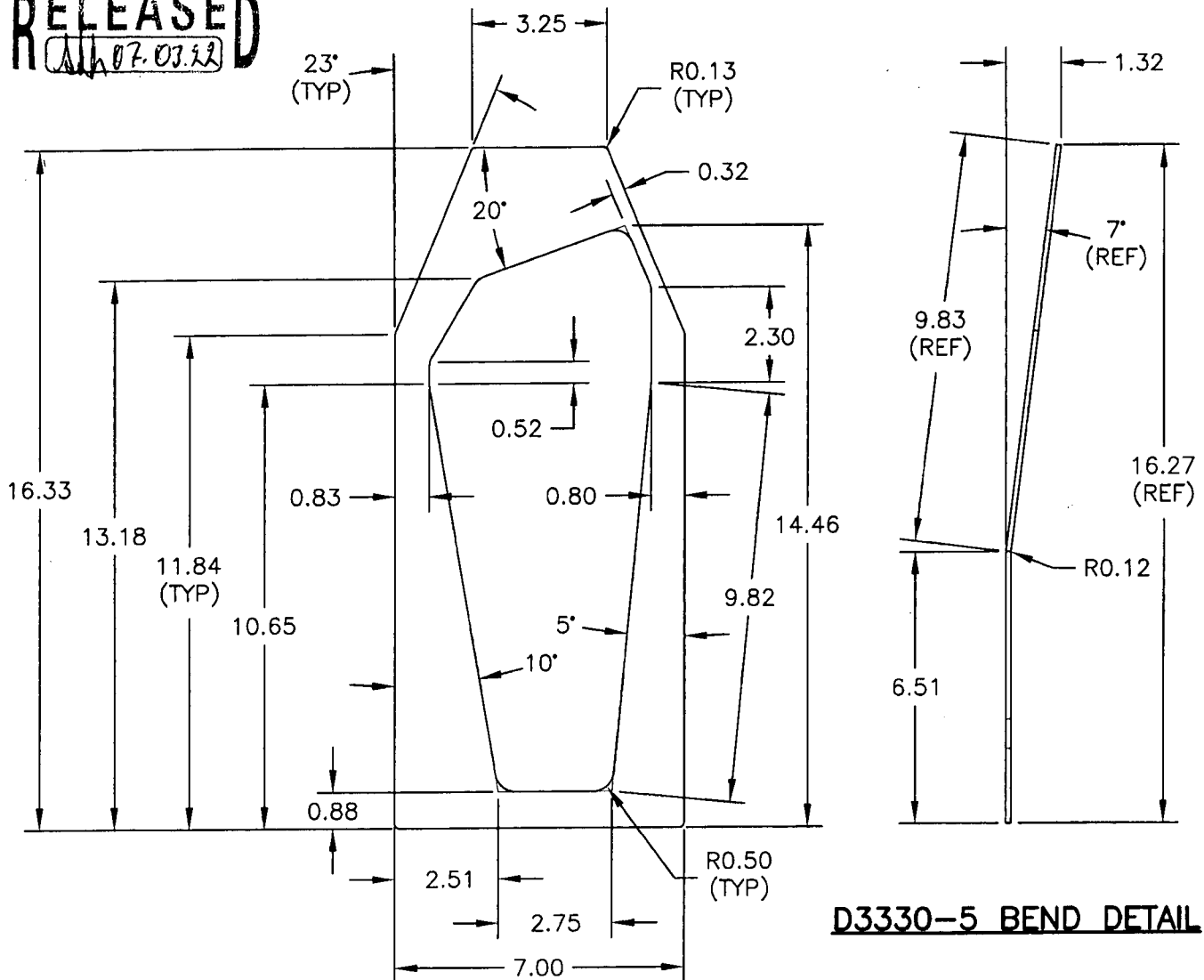
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.03.22



D3330-5 BEND DETAIL

FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 IN THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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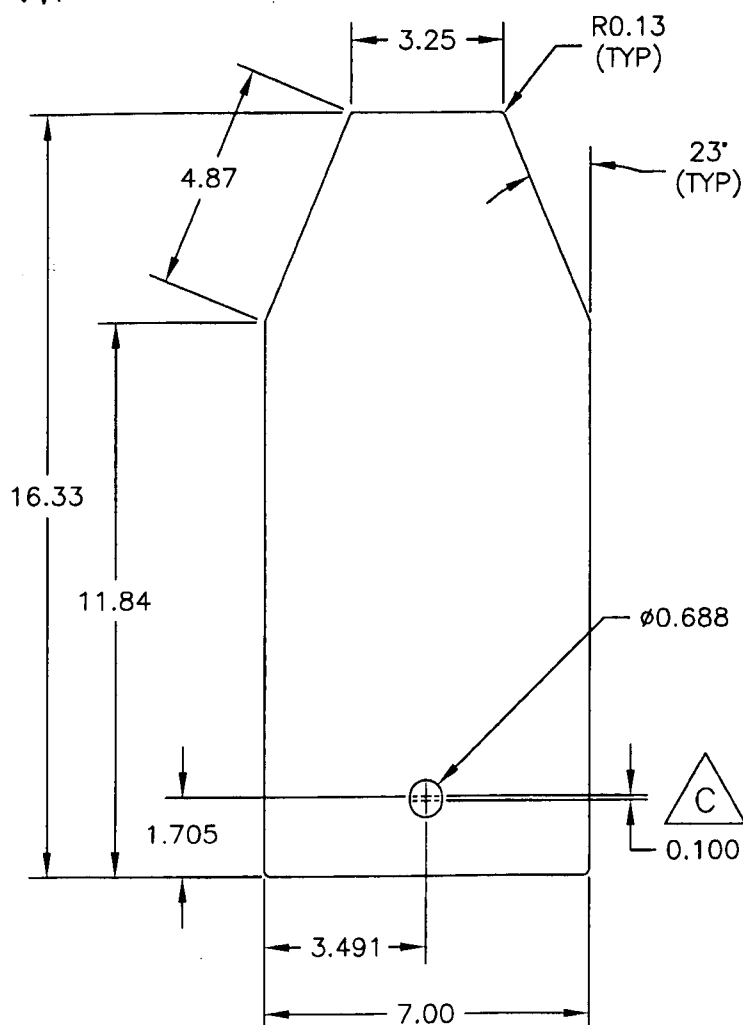
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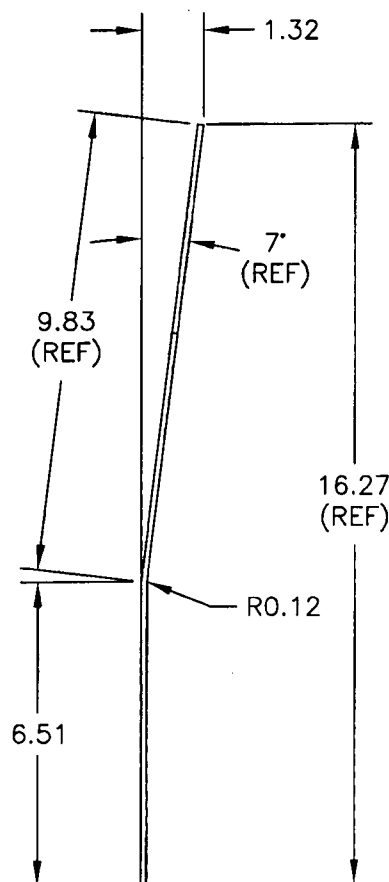


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DATE 07.03.20		TITLE FRAME ASSEMBLY	SCALE 1:4

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07.03.22



FLAT PATTERN



D3330-7 BEND DETAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

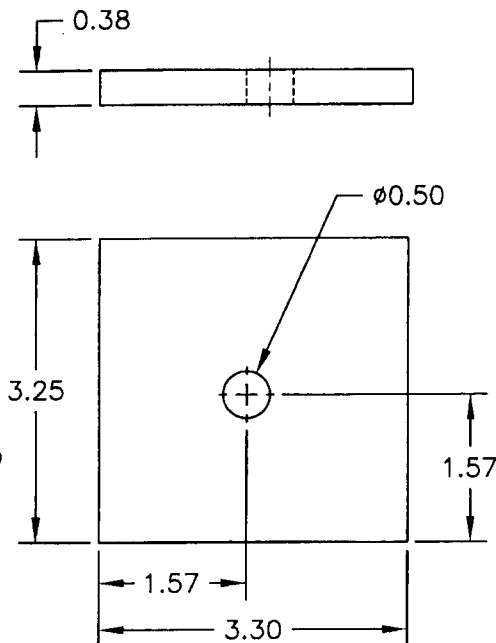
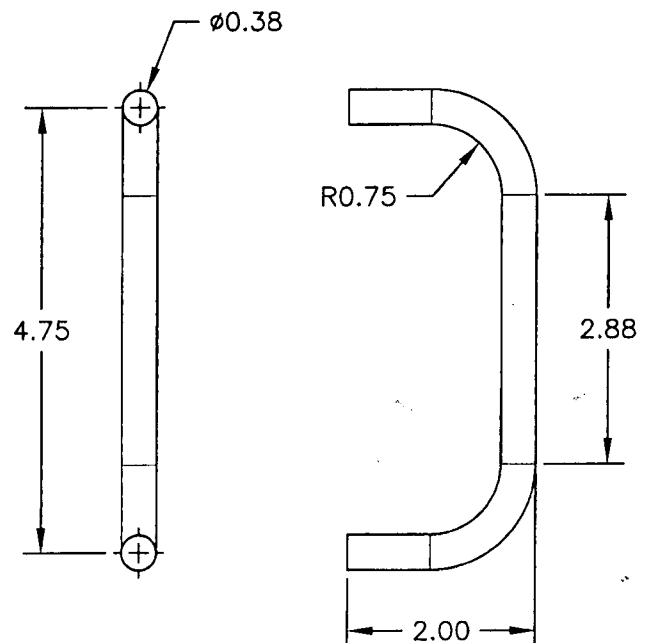
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DART

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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED
07.03.22**1 D3330-9 TOP PLATE****2 D3330-15 HANDLE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL (REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097 (REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

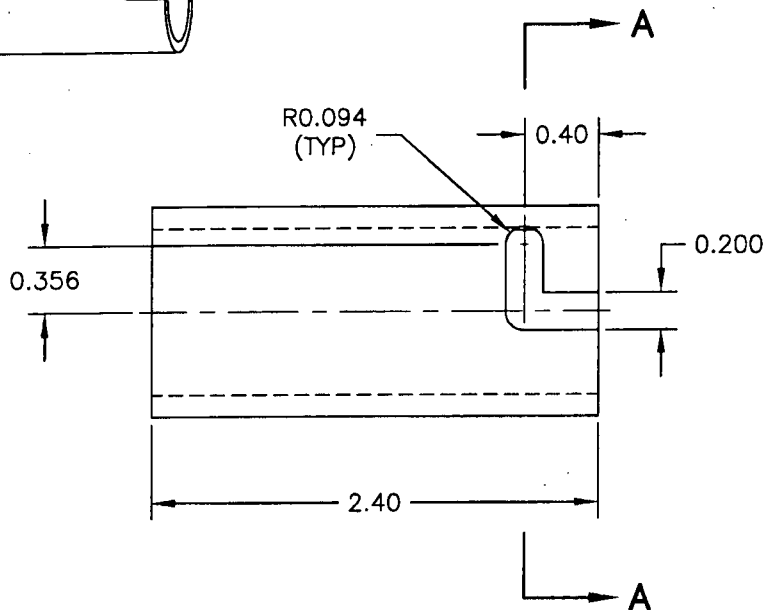
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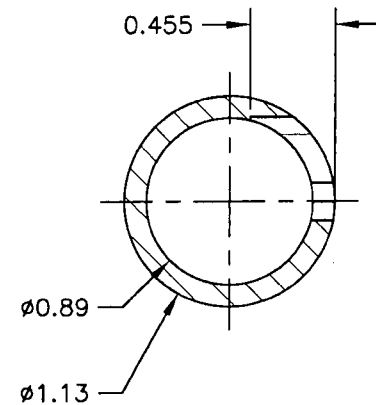
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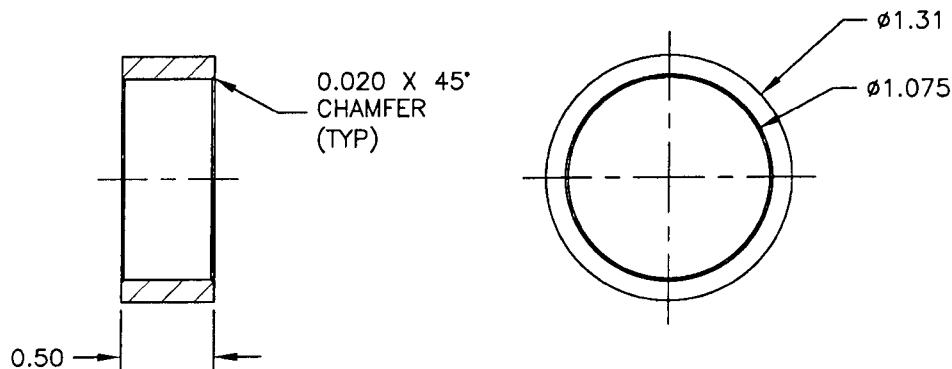


RELEASED
07-03-22



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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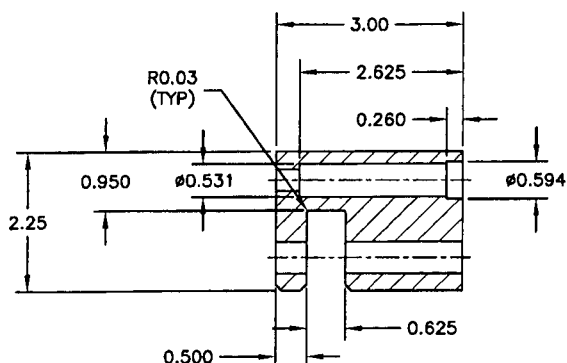
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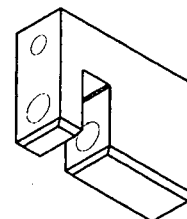
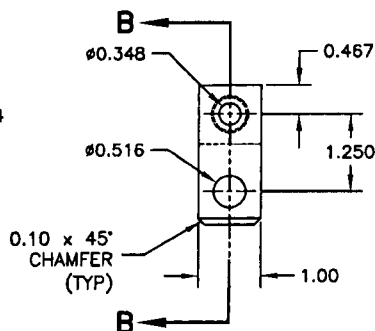


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DATE 07.03.20		REV. C SHEET 9 OF 9
		TITLE FRAME WELDMENT
		SCALE 1:3

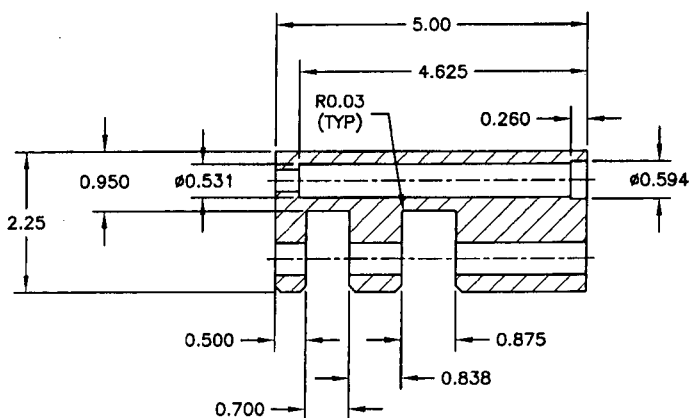
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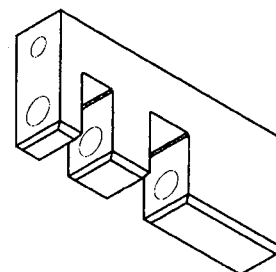
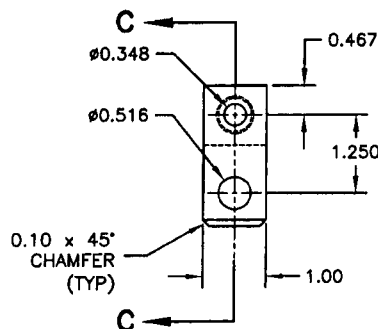
SECTION B-B



D3330-13 SHORT PIN BRACKET



SECTION C-C



D3330-11 LONG PIN BRACKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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